	Work Order ID 74007 Tuesday, September 20, 2011 11:16:52 AM										Page 1
Item ID:	D3480-5	- I had distance -		Accept				Setup	Start		
Revision ID:						38111 81811 88181 11811 881					
Item Name:	Eyeball Adapt	-	i ipacii bibi ibbi						Stop		
Start Date: Required Date:	9/20/2011	Start Qty: 4.00			Cust Item II):					
Reference:	10/3/2011	Req'd Qty: 4.00			Customer:						
Approvals:	Process Pla	ın:		Tooling:	Da	te:	-	Run	Start		
	QC:	1	Date:	SPC (Y/N):	Da	te:	-		Stop		
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool # Plan Code	Acce _l Qty\	pt Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr					(6)				
D3480	Rev	C									
Waterjet FLOW CNC Waterj	et	FLOW WATER JET Memo Cut as per: **USE D3 Dwg Rev:_ Prog Rev:_	Dwg D3480 480-1 CUTTING FILE**	0.00		ar O				12-6-	->7
QC Quality Control		QC2- Inspect parts off r	nachine FAI/FAIB	0.00	Seo II	let pet ill be t	lem outson	arcl	4	<u>্য</u>	17-6-77
120 QC Quality Control		QC8- Inspect parts - sec	cond check	0.00 5,7/cc	\z>	from	WIW (16		14"	U-23	

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		WO	RK ORDER CH	ANGES					
STEP	PRO	OCEDURE CHAN	IGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
·	PAR #:	Fault Categ	ory:	NC	R: Yes I	No DQ	A:	_ Date: _	
R	Resolution:	Disposition	•	QA	: N/C Clo	sed:		Date: _	
		WORK ORDE	R NON-CONFO	RMANCE	(NCR)			
STEP	Description of NC			Section B	Sign &			Approval	Approval
	Section A	Chief Eng	Chief Eng		Date	Sect	on C	Chief Eng	QC Inspector
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		-							
									;
	F	:PAR #: Resolution: STEP Description of NC Section A	STEP PROCEDURE CHAN PAR #: Fault Category Resolution: Disposition WORK ORDE STEP Description of NC Section A Initial Chief Eng	STEP PROCEDURE CHANGE PAR #: Fault Category: Resolution: Disposition: WORK ORDER NON-CONFO STEP Description of NC Section A	PAR #: Fault Category: NCI Resolution: Disposition: QA WORK ORDER NON-CONFORMANCE WORK ORDER NON-CONFORMANCE STEP Description of NC	STEP PROCEDURE CHANGE By PAR #: Fault Category: NCR: Yes for the second sec	STEP PROCEDURE CHANGE By Date :PAR #:Fault Category:NCR: Yes No DQ. Resolution:Disposition:QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC	STEP PROCEDURE CHANGE By Date Qty	STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr :PAR #: Fault Category: NCR: Yes No DQA: Date: Resolution: Disposition: QA: N/C Closed: Date: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Section A

Work Order ID 74007

Tuesday, September 20, 2011 11:16:53 AM



Page 2

Item ID:

D3480-5

Accept

Setup Start

Stop



Revision ID:

Item Name:

Eyeball Adapter Flange

Start Date:

9/20/2011

Start Qty: 4.00

Required Date: 10/3/2011 Req'd Qty: 4.00



Cust Item ID:

Customer:

Reference

Reference:								~.		
Approvals:	Process Pla	in:	Date:	Tooling: SPC (Y/N):		ate:	R	tun Sta Sto		
Sequence ID/		Operation		Set Up/	Tool ID	Tool # Plan	Accept	Reject	Reject	Insp.
Work Center I 130 Small Fab	D	Description Small Fab Memo		0.00 0.00		Code DAS	Qty	Qty	Number	Stamp
Small Fab			er dwg D3467 using DT88	356 GOV		30 9-89				
		QC5- Inspect part comp	leteness to step on W/O	0.00						

150

QC

Packaging

Quality Control

Identify as per dwg & Stock Location:____

0.00

0.00

Memo

Memo

0.00

Packaging

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Dart Aerospace	Ltd
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		WORK ORDER CHANGES							
STEP		PR	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							<u> </u>		
:		PAR #:	Fault Category:	NCF	R: Yes	No DQ	A:	Date: _	
R	lesolution:		Disposition:	QA:	N/C (Closed:		Date: _	
			:PAR #:	STEP PROCEDURE CHANGE :PAR #:Fault Category:	STEP PROCEDURE CHANGE PROCEDURE CHANGE PAR #: Fault Category: NCF	STEP PROCEDURE CHANGE By :PAR #:Fault Category:NCR: Yes	STEP PROCEDURE CHANGE By Date :	STEP PROCEDURE CHANGE By Date Qty :	STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr

NCR:		V	VORK ORD	ER NON-CONFORMANO	CE (NCR)			
		Description of NC		Corrective Action Section B		Verification	Approval Chief Eng	Approval QC inspector
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		
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Tuesday, September 20, 2011 11:16:53 AM



Page 3

Item ID:

D3480-5

Accept

Setup Start

Stop



Revision ID:

Start Date:

Item Name:

Eyeball Adapter Flange

9/20/2011

Start Qty: 4.00

Required Date: 10/3/2011

Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals:	Process Plan:QC:	Date:	Tooling: SPC (Y/N):		ate:	,	R	tun Sta Sto			
Sequence ID/ Work Center II	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	_
	QC21- Final Inspec	ction - Work Order Release	0.00					- 0		F	

Quality Control

Memo

0.00

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Dart Aerospace Ltd

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W/O:			WO	RK ORDER CHANGE	S				•
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	Re	solution:	Disposition);	QA: N/C CI	osed:		Date: _	
NCR:			WORK ORDE	ER NON-CONFORMA	NCE (NCF	1)			
DATE	STEP	Description of NC		Corrective Action Section	n B Sign 8		cation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Date	Secti	ion C	Chief Eng	QC Inspector
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Picklist Print

Tuesday, September 20, 2011 11:17:00 AM

Work Order ID: 74007

Parent Item:

D3480-5

Parent Item Name: Eyeball Adapter Flange



Start Date: 9/20/2011

Required Date: 10/3/2011

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP rev. A 06.02.07 new issue

Item ID

Replacement Mfg/

EC

Primary Location	Last Location	Route Seq ID		Qty per Kit	Total Otv	Qty Issued	Date Issued	Status	_

Item Name

Purchased

Purch

No

Qty

0.320160

Page 1

M304S26GA

304/316 0.018 SHEET

Component Item ID/

Location

MAT020

117798

Loc Qty

94.8 94.8

sf

Loc Code

94.8000



1812-6-27

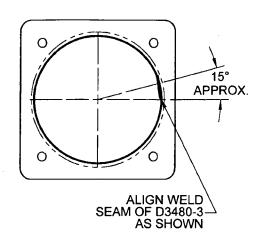
Dart Aerospace Ltd

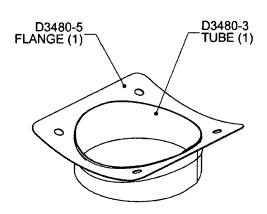
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DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DATE	STEP	Description of NC		Corrective Action Section		Verifi	cation	Approval	Approval
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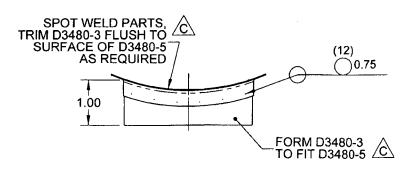


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DESIGN		DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, C.	
CHECK	ED	APPROVED	DRAWING NO.	REV. C
<i>f</i>	#		D3480	SHEET 1 OF 6
DATE		•	TITLE	SCALE
	08.1	12.19	EYEBALL ADAPTER	1:2
Α	0	6.02.06	NEW ISSUE	
В	0	6.08.29	D3480-3 0.50 was 0.40/D3480-3F 8	3.930 was 9.330
С	0	8.12.19	D3480-3 PICTORIAL CHG PER D3 & 4); ADD/REV TOL (SHT 3-5); AD (SHT 4); MATL SPEC WAS MIL-S-	480-3F (SHT 1 D MFG NOTE 5019









SHOP CORY RETURNS 41 ENGINE ARTISTS UNCONTROLLED COME SUBJECT TO AMENDMENT WITHOUT NOTICE

N11.09-20

D3480-041 EYEBALL INLET ADAPTER

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
 3) IDENTIFY WITH DART P/N D3480-041 USING
 FINE POINT PERMANENT INK MARKER
 4) TOLERANCES ARE PER DART QSI 018 UNLESS
- OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION	
Х	D3480-041	EYEBALL INLET ADAPTER	
1	D3480-3	TUBE	
1	D3480-5	FLANGE	

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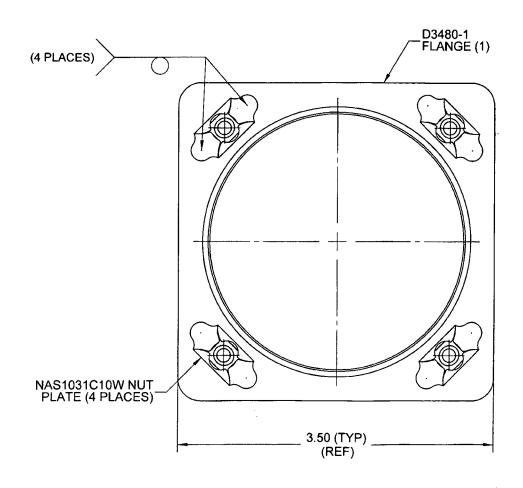
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W/O:			WC	ORK ORDER CHANGE	S				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	·	PAR #:	Fault Category: N			No DQ	A:		
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DATE	STEP	Description of NC		Corrective Action Section		Verific	ication Approval	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		on C	Chief Eng	QC Inspector
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DESIGN	DRAWN BY	DART AEROSPA HAWKESBURY, ONTAR	
CHECKED	APPROVED	DRAWING NO.	RĒV. C
PH	784	D3480	SHEET 2 OF 6
DATE		TITLE	SCALE
08	.12.19	EYEBALL ADAPTER	1:1





74007

D3480-043 EYEBALL ADAPTER

NOTES:

- 1) SPOT WELD PER DART QSI 004
 2) FINISH: NONE
 3) IDENTIFY WITH DART P/N D3480-043 USING FINE POINT PERMANENT INK MARKER
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 5) ALL DIMENSIONS ARE IN INCHES
 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -043	P/N	DESCRIPTION
Х	D3480-043	EYEBALL ADAPTER
1	D3480-1	FLANGE
4	NAS1031C3W	NUTPLATE

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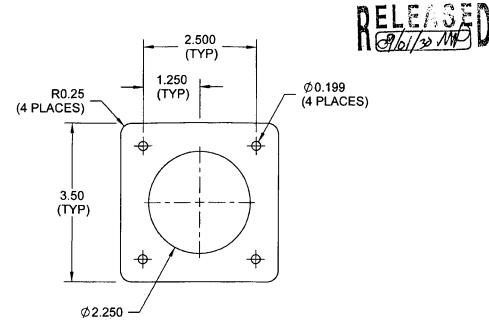
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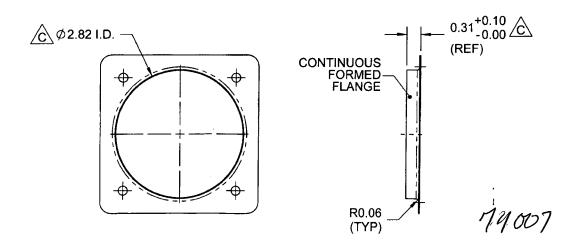
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DATE STEP		PROCEDURE CHANGE			Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Resolution:			Disposition	QA: N/C Closed:				Date:		
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DESIGN	DRAW BY	DART AEROSPAC HAWKESBURY, ONTARIO,	
CHECKED	APPROVED	DRAWING NO. D3480	REV. C SHEET 3 OF 6
DATE 08	.12.19	TITLE EYEBALL ADAPTER	SCALE 1:2



D3480-1F FLAT PATTERN



D3480-1 FLANGE (MAKE FROM D3480-1F)

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 3) ALL DIMENSIONS ARE IN INCHES 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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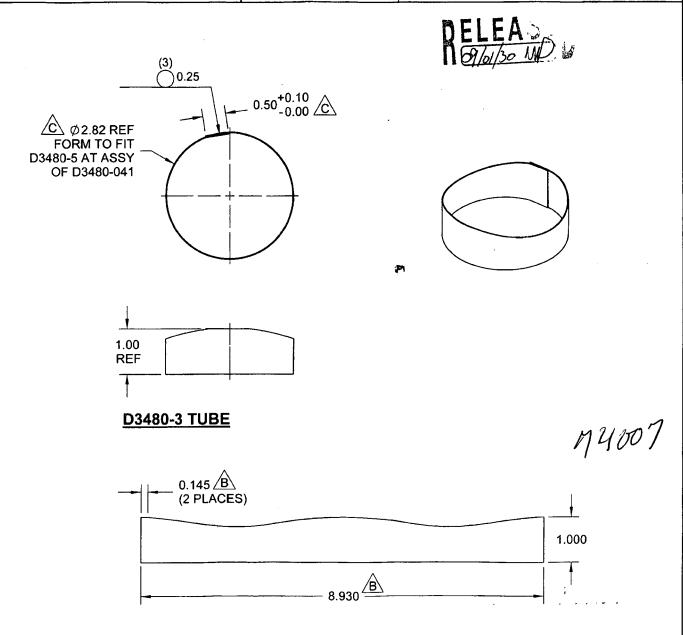
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W/O:			WO	RK ORDER CHANGE	S										
DATE STEP		PRO	PROCEDURE CHANGE By Date Q			PROCEDURE CHANGE By Date		By Date			By Date Qty		Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
 															
Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	No DQ	A:	Date: _							
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DATE	CTED	Description of NC			n B	Verific	cation	Approval	Approval						
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti		Chief Eng	QC Inspector						
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PH	AN'	D3480	SHEET 4 OF 6
DATE		TITLE	SCALE
30	3.12.19	EYEBALL ADAPTER	1:2



D3480-3F TUBE FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 3) ALL DIMENSIONS ARE IN INCHES
 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

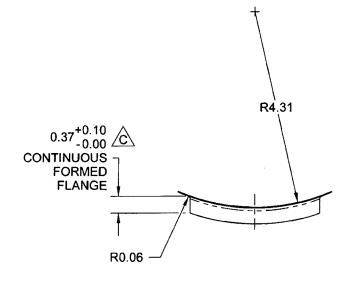
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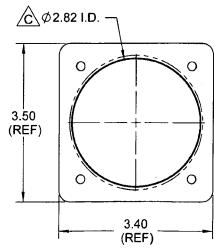
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DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
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Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	No DQ	A :	Date: _	
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NCR:			WORK ORDE	R NON-CONFORMAN	CE (NC	₹)			
DATE	CTED	Description of NC	Corrective Action Section			Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	ion C	Chief Eng	QC Inspector
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CHECKED	APPROVED	DRAWING NO.	REV. C
PH	-68	D3480	SHEET 5 OF 6
DATE		TITLE	SCALE
08.12.19		EYEBALL ADAPTER	1:2







D3480-5 EYEBALL ADAPTER FLANGE

NOTES:

- 1) MATERIAL: MAKE FROM D3480-1F 2) FINISH: NONE 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4) ALL DIMENSIONS ARE IN INCHES 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

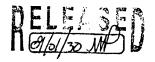
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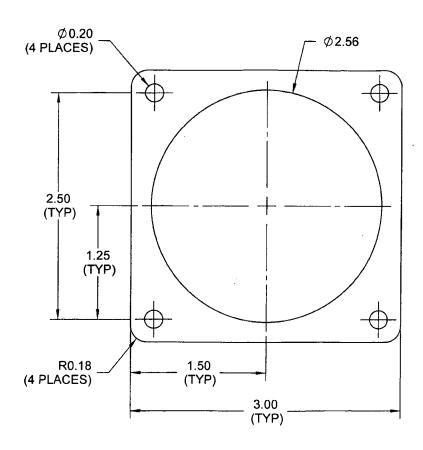
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W/O:			WO	RK ORDER CHANGI	ES				
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Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date: _	
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NCR:			WORK ORDE	ER NON-CONFORMA	NCE (NCF	?)			
DATE	STEP	Description of NC		Corrective Action Section		Verifi	cation	Approval	Approval
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PA		D3480	SHEET 6 OF 6
DATE		TITLE	SCALE
08.12.19		EYEBALL ADAPTER	1:1





14007

D3480-7 GASKET

NOTES:

- 1) MATERIAL: RED (OR GRAY) 60 DUROMETER HI-TEMPERATURE SILICONE SHEET, O.125" THICK (REF. DART SPEC. M-SIL60-.125)
 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 3) ALL DIMENSIONS ARE IN INCHES
 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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		Description of i	NC	Corrective Action Section		Verification	Approval	Approva
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspect
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DART AEROSPACE LTD	Work Order:	74007
Description: EYEBALL ADAPTOR FIREGE	Part Number:	D3480-5
Inspection Dwg: つみにして Rev: C	•	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	rawing mension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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Measured by: + B	Audited by:	Preliminary Approval:	
Date: (2-6-77	Date: 762	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	